

# Work Order ID 55585

January 22, 2010 10:29:36 AM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 1/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *PR*

Date: *10-1-22* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

*S. 10/02/22*

*HJ GA MF 10/02/22*

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek *M113785*

*PR 10-1-22*

*Rev 4/27 C*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 55585**

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January 22, 2010 10:29:36 AM

Item ID: D350-604-041

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Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 1/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



Packaging

Receive & Inspect for Damage & Mat'l Certs  
Packaging

0.00

Memo

0.00

Packaging

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

130



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

Check hole locations to template. DT 8824 Check process sheet and audit.

S. 10/02/22

140



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

10-2-22 J

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 55585**

January 22, 2010 10:29:36 AM

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Item ID: D350-604-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rear Locker Extender

Start Date: 1/22/10 Start Qty: 1.00

Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 1.00

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00	S 10/02/22			(to)			
160  Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D350-604-041 <input type="checkbox"/> Location: _____ <input type="checkbox"/> PPP Rev: <u>F</u>	0.00 0.00				P 10/02/22 (1)			
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00				10/02/23 ME 10-2-22			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

January 22, 2010 10:31:29 AM

Work Order ID: 55585

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Comments: IPP Rev:Q03.12.01 ReformatKJ/RF

Start Date: 1/22/10

Required Date: 1/29/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

2600-6		Purchased	No			100	Each	28.0000	4.0000			
--------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--



Camlock Stud

M113795 1/10/1/27 ①

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

28

109158

3

112919

1

113482

24

Manufactured No

120

Each

13.0000

1.0000

10-2-22 SP

D2269



Decal

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3

52916

3

Main Warehouse

ST10

10

55327

10

D350-604-041P

Purchased

No

140

Each

0.0000

1.0000



Rear Locker Extender

55585 10-2-22 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 2

January 22, 2010 10:31:29 AM

Work Order ID: 55585



Parent Item: D350-604-041



Parent Item Name: Rear Locker Extender

Start Date: 1/22/10

Required Date: 1/29/10

Comments: IPP Rev:Q03.12.01 Reformat KJ/RF

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2268

Manufactured

No

150

Each

21.0000

1.0000



10-2-22

Decal

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST010

21

53484

11

55453

10

January 22, 2010 10:31:29 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

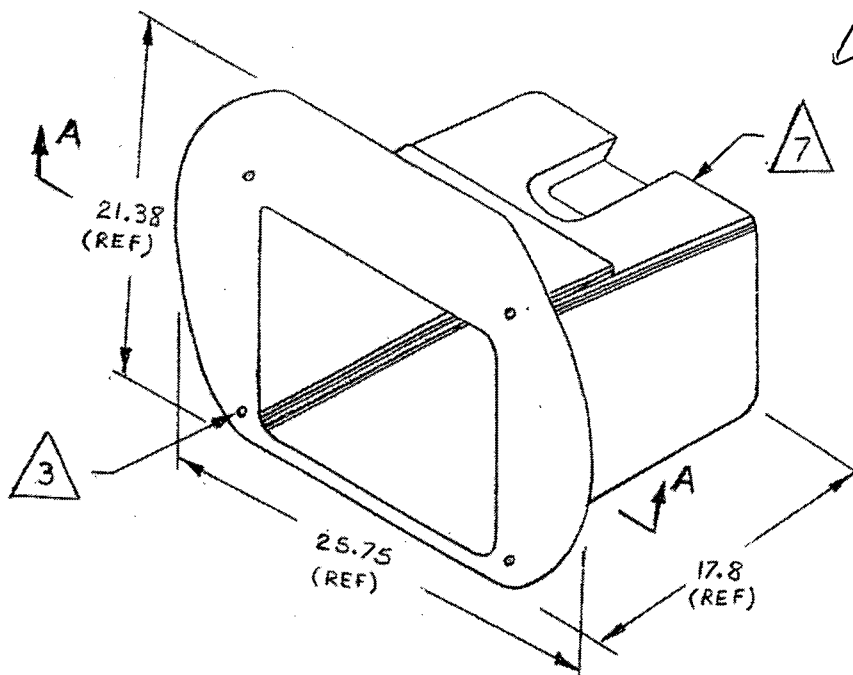
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



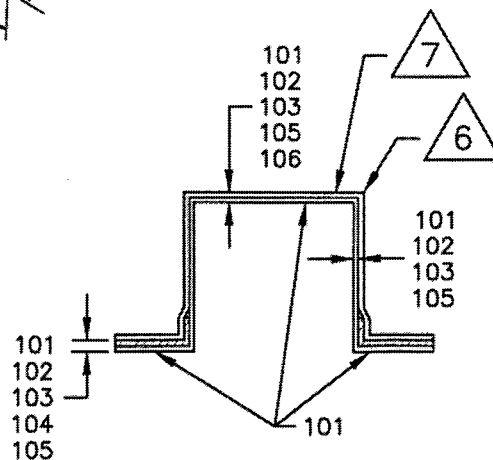
DESIGN	JB	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	DRAWING NO. D2273 REV. D SHEET 1 OF 1
DATE	02.04.01	TITLE	350 REAR LOCKER EXTENDER SCALE NTS
B	96.05.27	RE-DRAWN	
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING	
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH	

RELEASED  
02.04.03 *[Signature]*



**NOTES:**

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO  $\phi 0.257$  (4 PLACES).
- 4) MATERIALS:  
RESIN: DERAKANE 470-36/411/510A40  
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS  
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:  
101-WHITE GLOSS GELCOAT # GEL 944W005.  
102-9oz ALL OVER.  
103-18oz ALL OVER.  
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.  
105-9oz ALL OVER.  
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.



SECTION A-A

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13315
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
17/02/2010	22/01/2010	6097	Chantal Lavoie		PO11203		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	LINE #4 Rear Locker Extender D350-604-041P B55585 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D Job: 24172			
1	0	1	DKC134-0003	LINE #5 Rear Locker Extender D350-604-041P B55584 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D Job: 24173			
1	0	1	DKC134-0003	LINE #6 Rear Locker Extender D350-604-041P B55583 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D Job: 43993			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Continued on next page

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Mercredi, 2010-01-27 10:05:52

Savoir: Louis Jodoin

## Feuille de Procédé

Client : DART LUS DART AEROSPACE LTD  
 Numéro Job : 24172  
 Numéro Soumission : 3482  
 Numéro B.A. :  
 Date : 2010-01-27 No. B.V. :  
 Révisé : NC  
 Nombre de fois : - - - Type :  
 Numéro précédente : 23900

Nom Dessin : REAR LOCKER EXTENDER  
 Numéro Article : DKC134-0003  
 Numéro Dessin : D350-604-041 & D2273  
 Projet Numéro : DK-362  
 Révision dessin : A & D  
 Matériel : Derakane 470-36/411/510  
 Date Due : 2010-02-03 Qté: 1 Udm: UNITE

Approuvé par :  
 Approuvé & Approuvé par :  
 Commentaires : N° de pièce Laminée Dart Aerospace: D2273  
 N° de pièce Assemblage Dart Aerospace: D350-604-041

Process Sheet Rév.: 00 Création du premier à partir de la révision  
 12 du planning De Delastek Composites

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0085	FREKOTE 3,78L 44-NC

Commentaire Qty.: 0.02 UNITE(s)/Unit Total : 0.02 UNITE(s)

2.0 PRÉPARATION Préparation du moule



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Nettoyer le moule à l'aide d'un chiffon humide et sécher à l'air. Selon I.F. # DKC134-0003-5.

Note: Afin que le frekote agisse pleinement, le moule doit être libre de toute contamination, enlever tout contaminants à l'aide de Frekote PMC, PMC Plus ou tout autre solvant efficace. Il est permis d'utiliser un abrasif (Doux) afin d'enlever toute accumulation de résine sur le moule.

Appliquer 2 couches de Frekote 44-NC à l'aide du chiffon propre en laissant sécher pendant 15 minutes entre les couches. Le séchage de la dernière couche doit être de 3 heures à température de la pièce avant d'appliquer le Gel Coat.

Date: 5/02/10 Sceau:



08-02-10



3.0 AMB0350

Gel Coat Blanc N° Gel 944W005

Commentaire Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)

Gel Coat Blanc N° Gel 944W005

N° de Lot: 1-26332-1

4.0 AMB0286

Catalyst N° DDM-9

Commentaire Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

Client: DART US DART AEROSPACE LTD  
Numéro Job: 24172

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003


uméro Job:



Séq.:	Machine ou Opération:	Description :
5.0	AC0747	Acetone
Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)		
6.0	PREP-GENERAL	Préparation du matériel
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs		

Faire la préparation du matériel selon I.F. # DKC134-0003-5 :

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 8/02/10 Sceau: 


7.0	GEL COAT	Application du Gel Coat
Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs		

Selon I.F. 134-0003

À l'aide d'un fusil à gel coat appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DKG 362-010 et laisser sécher pendant un minimum de 2 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. ( Visuel du Gel Coat )

Date: 8/02/10 Sceau: 

8.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Commentair Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)		
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-26477-1		
9.0	AMB0286	Catalyst N° DDM-9
Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)		
Catalyst N° DDM-9 N° de Lot: 1-22176-1		
10.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
Commentair Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)		
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-26083-1		

Client: DART US DART AEROSPACE LTD  
Numéro Job: 24172

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:



# Séq.: Machine ou Opération: Description :

11.0 AMB0213 WR1850 Roving 18oz. x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)  
WR1850 Roving 18oz. x 50" N° de Lot: 1-22302-1

12.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Autocontrôle de fabrication. ( Selon gabarits )

Date: 08-02-10 Sceau:



13.0 LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon I.F. 134-0003

S'assurer de ne pas trapper d'air entre les rangs

Inscrire les informations suivantes:

Humidité: 22% Température: 70°F Heure: 4:00

Date: 08-02-10 Sceau:



14.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total : 0.150 LITRE(s)  
Résine (411B7530) 411-350 promo. 75min N° de Lot: \_\_\_\_\_

15.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: \_\_\_\_\_

16.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon I.F # DKC134-0003-5.

Date: \_\_\_\_\_

Sceau: \_\_\_\_\_



Numéro Job:



# Séq.:	Machine ou Opération:	Description :
17.0	DÉMOULAGE	Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F.# DKC134-0003-5.

Faire le démoulage de la pièce en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager .

Autocontrôle de fabrication.( Visuel )

Date: 9-2-10 Sceau:



18.0	TRIMAGE	Trimage / Rivetage
------	---------	--------------------



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon I.F.134-0002

Autocontrôle de fabrication.( Visuel et dimensionnel selon le dessin )

Date: 9-2-10 Sceau:



19.0	AAC1021	Dupont Primer N° 7704S
------	---------	------------------------

Commentair Qty.: 0.3400 UNITE(s)/Unit Total : 0.3400 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-26006-1

20.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
------	---------	---

Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 2-24803-3

21.0	PRIMER	Application primer
------	--------	--------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon I.G. 0008

Date: 12/02/10 Sceau:



22.0	AAC1607	Camlock Stud 2600-4 (or Monadnock 1126000-4)
------	---------	--

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)  
Camlock Stud 2600-4 (or Monadnock 1126000-4) N° de Lot: 1-26281-1

Form: mncss

uméro Job:



Séq.: Machine ou Opération: Description :

23.0 AAC0682 Washer 2600-LW (1127700)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)  
Washer 2600-LW (1127700) N° de Lot: 1-6687-1

24.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Selon I.F. 134-0004

Démasker la pièce.

Assembler les quatre (4) Camlock Stud N° 2600-4 à l'aide des Lock Washer N° 2600-LW. Selon l'instruction de travail N° I.G.#Pose de stud.

Autocontrôle de l'assemblage ( Visuel )

Date: 15-2-10 Sceau:

Identification à encre indélébile

25.0 IDENTIFICATION



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F. 134-0005

Faire l'identification de la pièce: N° de pièce D350-604-041  
N° de Work Order: \_\_\_\_\_

L'identification doit être vers l'extérieur.

Date: 15-2-10 Sceau:

Inspection finale

26.0

INSPEC FINAL



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 16-02-10 Sceau:

Emballage &amp; Entreposage

27.0

EMBALLAGE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage de la pièce dans le contenant approprié.

Form: mprocess

sateur: Louis Jodoin

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 24172

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Qty 1

Date: 16-02-10 Sceau:



Form: mmp0000